

Date: Friday, 28/11/2008 2:54:38 PM  
 User: Julie Dawson

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: STEP SPACER
Job Number	: 43858B		
Estimate Number	: 10378		
P.O. Number	:	Part Number	: D30653
This Issue	: 28/11/2008 S.O. No. :	Drawing Number	: D3065 REV. B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : SMALL /MED FAB	Drawing Revision	: B
Previous Run	: 42344B	Material	:
Written By	:	Due Date	: 20/12/2008 Qty: 50 Um: Each
Checked & Approved By	: <u>JUD 08.12.01</u>		
Comment	: Est:C 02.11.01 Incorporated D3066-1 IPP KJ/RF Est Rev:D Now on Water Jet 06-04-11 JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S040	2024-T3 .040 sheet
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Comment: Qty.: 0.2287 sf(s)/Unit Total: 11.4345 sf(s)

Material: 2024-T3 (QQ-A-250/4) 0.040" thick

(M2024T3S.040)

Batch:

107461B8-12-19

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET

1-Cut as per Dwg D

Dwg Rev: BProg Rev: BB8-12-14

2-Deburr if necessary

B8-12-1954

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

B8-12-19

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

8 03/12/19counters54

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1  
Deburr Stacka/a8/12/19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 28/11/2008 2:54:38 PM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP SPACER

Job Number: 43858B

Part Number: D30653

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Bend as per Dwg D3065

*08/12/22* *08/12/22*

(54)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*08.12.23*

*(54) counted & stacked by 10's*

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

*ALM 9-1-06*

(54)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT CHEMICAL CONVERSION COAT

*09/01/07* *(54)*

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *Sylone* *GA*

*09/01/07* *(54)*

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*09/01/07*

Job Completion



*W 09.01.07*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

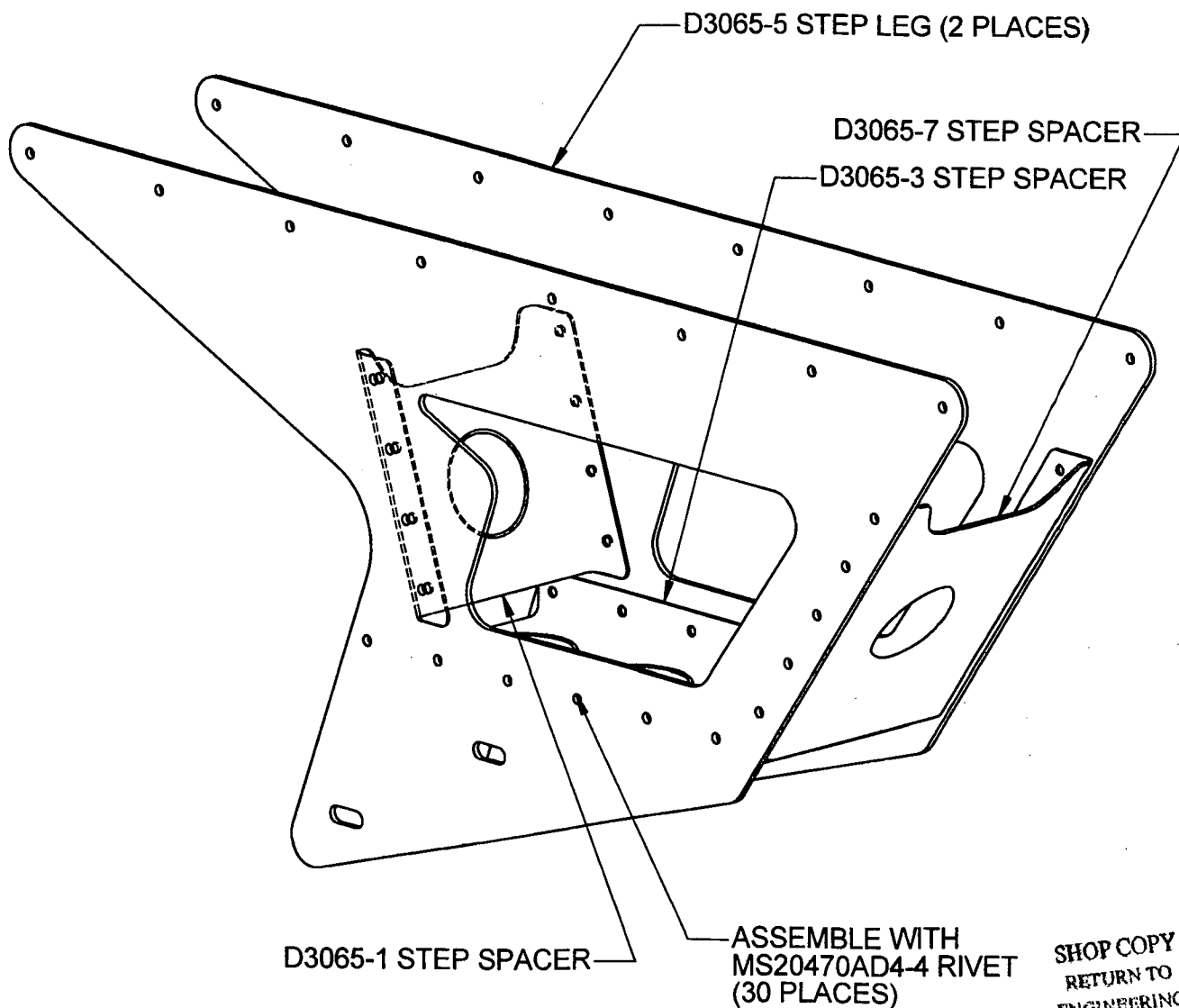




DESIGN <i>CP</i>	DRAWN BY <i>CB</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3065</b>	REV. B SHEET 1 OF 5
DATE <b>06.05.23</b>		TITLE <b>STEP LEG ASSEMBLY</b>	SCALE 1:2
A	02.09.11	NEW ISSUE	
B	06.05.23	ADD 6061-T6 MATERIAL, ADD SLOTS TO D3065-5	

RELEASED

06.06.20 *[Signature]*



**D3065-041 STEP LEG ASSEMBLY**

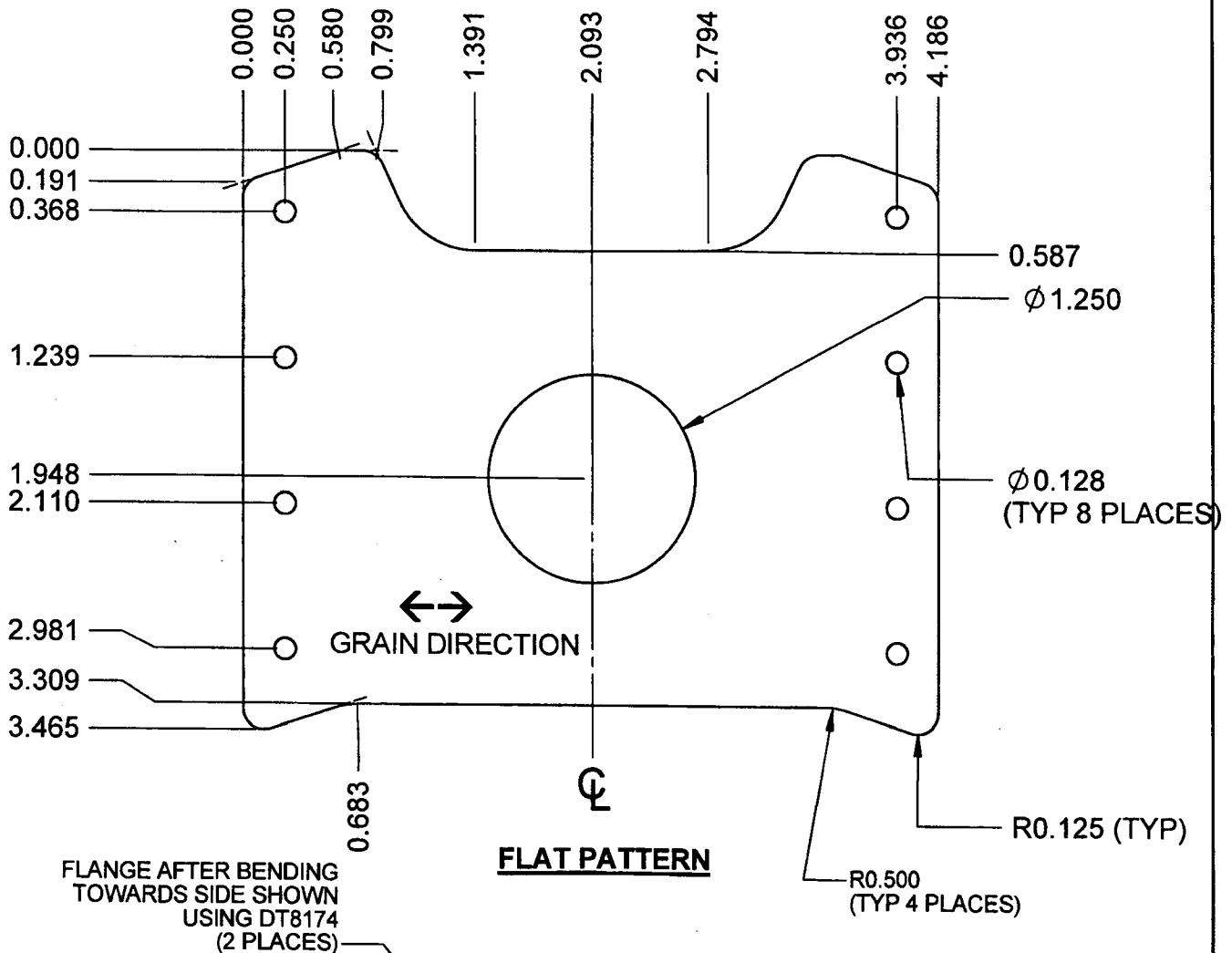
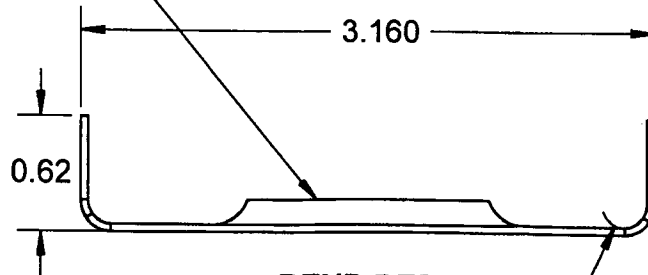
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DATE <b>06.05.23</b>		TITLE <b>STEP LEG ASSEMBLY</b>	SCALE 1:1

**RELEASED***CP CB***D3065-1 STEP SPACER**

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

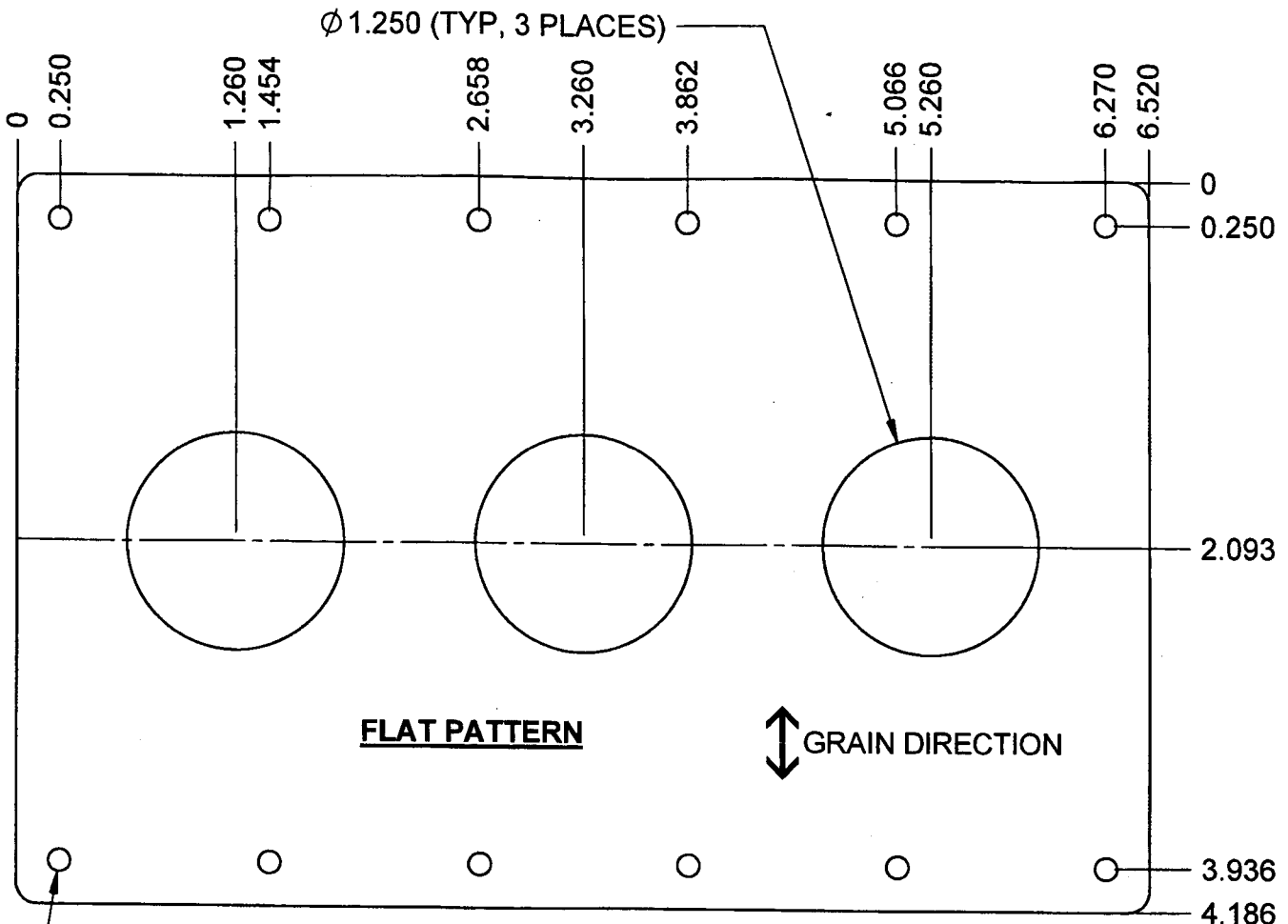
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CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3065</b>	REV. B SHEET 3 OF 5
DATE <b>06.05.23</b>		TITLE <b>STEP LEG ASSEMBLY</b>	SCALE 1:1

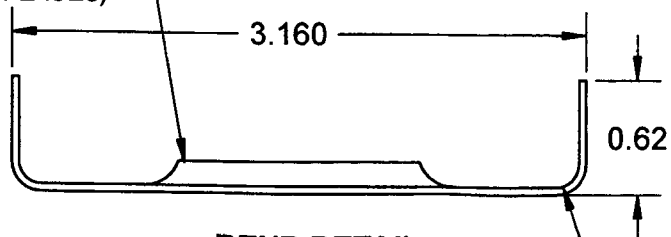


FLANGE AFTER TOWARDS SIDE  
SHOWN USING DT8174 (3 PLACES)

Ø 0.129 (TYP, 12 PLACES)

**RELEASED**

*06 06 20* *[Signature]*



**BEND DETAIL**

**D3065-3 STEP SPACER**

- 1) MATERIAL: 2024-T3 (QQ-A-250/4)  
0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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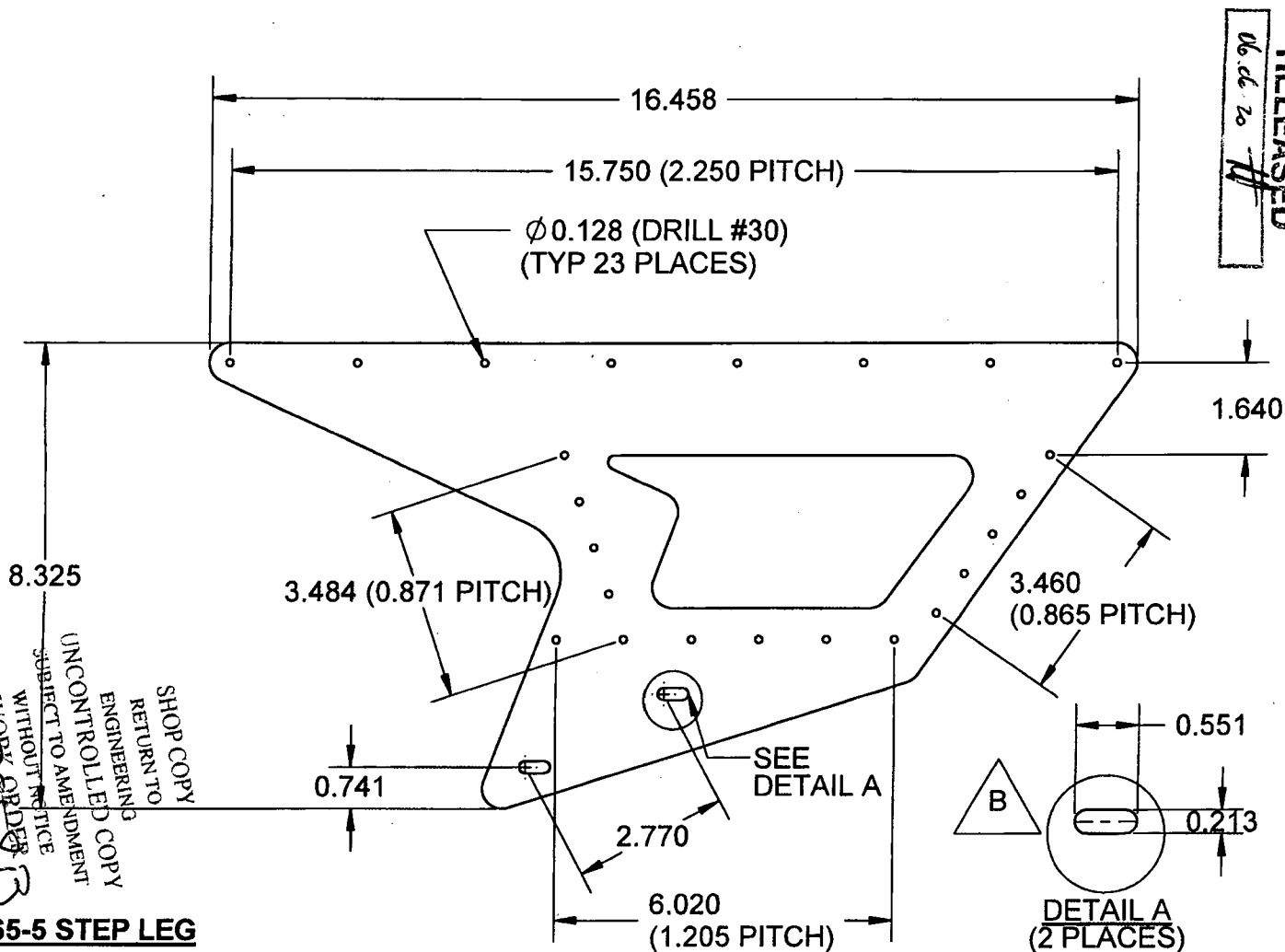


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C.B.	C.B.	DRAWING NO.	REV. B
CHECKED PH	APPROVED PH	D3065	SHEET 4 OF 5
DATE 06.05.23	TITLE STEP LEG ASSEMBLY	SCALE 1:3	

RELEASED

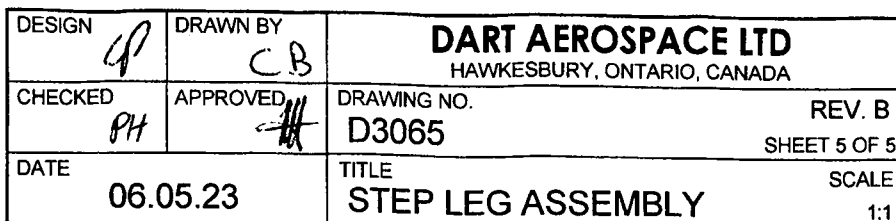
06.05.23

**D3065-5 STEP LEG**

- 1) MACHINE PER DWG FILE "D3065-5.SLDPRT"
- 2) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK (REF DART SPEC M6061T6S.080) OR 5052-H32 (PER QQ-A-250/8 OR AMS 4016) 0.080 THICK (REF DART SPEC. M5052H32S.080)
- 3) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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## FLAT PATTERN

**RELEASED**

OK OK 20 *[Signature]*

0.62

### BEND DETAIL

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### D3065-7 STEP SPACER

- 1) MATERIAL: 2024-T3 (PER QQ-A-250/4) 0.040 THICK (REF DART SPEC  
2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1  
3) PART IS SYMMETRIC ABOUT CENTERLINE  
4) BREAK ALL SHARP EDGES 0.005 TO 0.010  
5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
6) ALL DIMENSIONS ARE IN INCHES

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